



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5134-042
Job Sheet 197766



Part No: D5134-042

Job Qty: 6 pcs

Part Name: Damper Support Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/26/19

Created By: Manon Dubois

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off	
					Setup Hrs	Run Hrs	Workcenter / Supplier				
100	Bandsaw - 1	6 pcs	8/26/19	8/26/19	0.00	0.24	Bandsaw - 1			19/9/21	DAS 23 9-89
110	HAAS 4 Axis - B4B	6 pcs	8/26/19	8/26/19	1.00	13.95	HAAS - 1 - B4B			19/9/22	DAS 23 9-89
							HAAS - 2 - B4B				
							HAAS - 3 - B4B				
							HAAS - 4 - B4B				
120	QC 2	6 pcs	8/26/19	8/26/19	0.00	0.00	QC 2 - 1			19/9/22	DAS 23 9-89
							QC 2 - 12				
							QC 2 - 14				
							QC 2 - 17				
							QC 2 - 19				
							QC 2 - 2				
							QC 2 - 20				
							QC 2 - 22				
							QC 2 - 23				
							QC 2 - 25				
							QC 2 - 32				
							QC 2 - 33				
							QC 2 - 35				
							QC 2 - 39				
							QC 2 - 4				
							QC 2 - 40				
							QC 2 - 44				
							QC 2 - 45				
							QC 2 - 48				
							QC 2 - 49				
							QC 2 - 50				
							QC 2 - 51				
							QC 2 - 52				
							QC 2 - 57				
							QC 2 - 62				



Container No: S215820



Part: D5134 - 042
Job No: 197766
Serial No/Batch: S215820
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Newkensbury, ON K64 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/22/19



Container No: S215820



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Job No: 197766

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TEL.: 1 613 632-5200
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Date: 08/22/19

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7/16/2019

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130 QC 8	6 pcs	8/26/19	0.00	0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
135 Handfinish - 1-1 Chemical- B4B	6 pcs	8/26/19	0.00	0.60	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	

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[Dart Hawkesbury] Job Sheet - Dubois, Manon

					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
137 QC 7	6 pcs	8/26/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	DAS
					QC 7 - 41	41 19-10-2
					QC 7 - 47	9-89
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 Spray Paint - 2 - B4B	6 pcs	8/26/19	0.00	1.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-10-3
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
150 QC 14	6 pcs	8/26/19	0.00	0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
160 Small Fab - 2 - B4B	6 pcs	8/26/19	0.00	1.27	Small Fab - 1 - B4B	DAS
					Small Fab - 2 - B4B	61
					Small Fab - 3 - B4B	9-89

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[Dart Hawkesbury] Job Sheet - Dubois, Manon

170 QC 5	6 pcs	8/26/19	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
180 Packaging 3-1 - Stock - B4B	6 ✓ pcs	8/26/19	0.00 0.00	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

DAS
61
9-89

LE054 OCT 08 2019

Rosales, Oscar OCT 08 2019

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[Dart Hawkesbury] Job Sheet - Dubois, Manon

190 QC 21 - SA

6 ✓
pcs

8/26/19

0.00 0.00

QC 21 - SA - 21 ✓

QC 21 - SA - 70

QC 21 - SA - 53

LG 054

DAS

21 OCT 08 2019

9:55

* Part Op 100 - Bandsaw - CUT BLANK TO 5.125" LONG
 Descriptions: 110 - HAAS CNC Vertical Machine - Mill as per Dwg and folio FB342 DWG REV: FB343 FOLIO REV: B
 DEBURR
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 135 - Chemical Conversion Coat per QSI005 4.1
 137 - QC7-Inspect Chemical Conversion Coat
 140 - Spray Paint / NDT Room *Primer: 5195271 White: 5217125*
 150 - QC14- Inspect Spray Paint
 160 - Small Fab
 170 - QC5- Inspect part completeness to step on W/O
 180 - Identify as per dwg & Stock Location: _____
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"	2,5800 ft (.43 ea)	100-Bandsaw - 1	5906150
NAS77C6-021	Bushing	12 Ea (2 ea)	160-Small Fab - 2 - B4B	fm134833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B3.000X4.000	3	3	0
160-Small Fab - 2 - B4B	NAS77C6-021	12	191	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support, RH	0.360Inches $\pm$ 0.030	0.390 0.330		
2	Damper Support, RH	0.188Inches $\pm$ 0.005 - 0.001	0.193 0.187		
3	Damper Support, RH	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256		
4	Damper Support, RH	1.932Inches $\pm$ 0.010	1.942 1.922		
5	Damper Support, RH	0.632Inches $\pm$ 0.010	0.642 0.622		
6	Damper Support, RH	0.632Inches $\pm$ 0.010	0.642 0.622		
7	Damper Support, RH	0.730Inches $\pm$ 0.010	0.740 0.720		
8	Damper Support, RH	0.500Inches $\pm$ 0.000 - 0.001	0.500 0.499		
9	Damper Support, RH	0.100Inches $\pm$ 0.010	0.110 0.090		
10	Damper Support, RH	0.728Inches $\pm$ 0.010	0.738 0.718		
11	Damper Support, RH	0.250Inches $\pm$ 0.030	0.280 0.220		Radius
12	Damper Support, RH	0.630Degrees $\pm$ 0.030	0.660 0.600		Radius
13	Damper Support, RH	0.063Degrees $\pm$ 0.010	0.073 0.053		Radius
14	Damper Support, RH	0.117Inches $\pm$ 0.010	0.127 0.107		
15	Damper Support, RH	0.177Inches $\pm$ 0.010	0.187 0.167		
16	Damper Support, RH	0.841Inches $\pm$ 0.010	0.851 0.831		
17	Damper Support, RH	0.208Inches $\pm$ 0.010	0.218 0.198		
18	Damper Support, RH	0Degrees $\pm$ 0	0 0		
19	Damper Support, RH	0.860Inches $\pm$ 0.010	0.870 0.850		
20	Damper Support, RH	1.471Inches $\pm$ 0.010	1.481 1.461		
21	Damper Support, RH	0.130Inches $\pm$ 0.030	0.160 0.100		Radius

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DART AEROSPACE LTD		Work Order:	197766
Description: Damper Support, RH		Part Number:	D5134-042
Inspection Dwg: D5134 Rev: B		Page 1 of 1	

INSPECTION SHEET

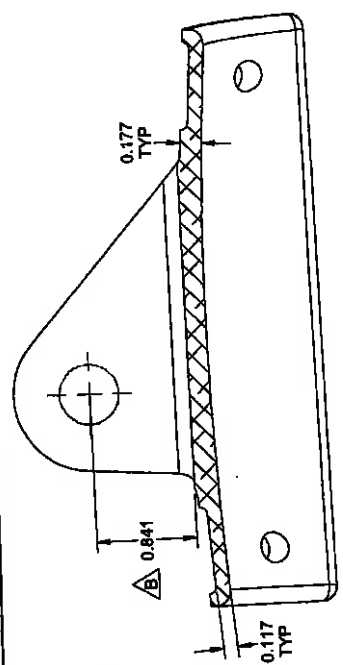
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.36	+/-0.030	0.36	✓			
Ø0.188	+0.005/-0.001	0.188	✓			
Ø0.257	+0.006/-0.001	0.257	✓			
1.932	+/-0.010	1.932	✓			
0.632	+/-0.010	0.632	✓			
0.632	+/-0.010	0.632	✓			
0.730	+/-0.010	0.730	✓			
Ø0.500	+0.000/-0.001	0.500	✓			
0.100	+/-0.010	0.100	✓			
0.728	+/-0.010	0.728	✓			
R0.25	+/-0.030	R0.25	✓			
R0.63	+/-0.030	R0.63	✓			
R0.063	+/-0.010	R0.063	✓			
0.117	+/-0.010	0.117	✓			
0.177	+/-0.010	0.177	✓			
0.841	+/-0.010	0.841	✓			
0.208	+/-0.010	0.208	✓			
0.208	+/-0.010	0.208	✓			
0.860	+/-0.010	0.860	✓			
1.471	+/-0.010	1.471	✓			
R0.13	+/-0.030	R0.13	✓			

Measured by:	VH8	Checked by:	P	QC Inspector:	
Date:	19/10/22	Date:	19-10-02	Date:	

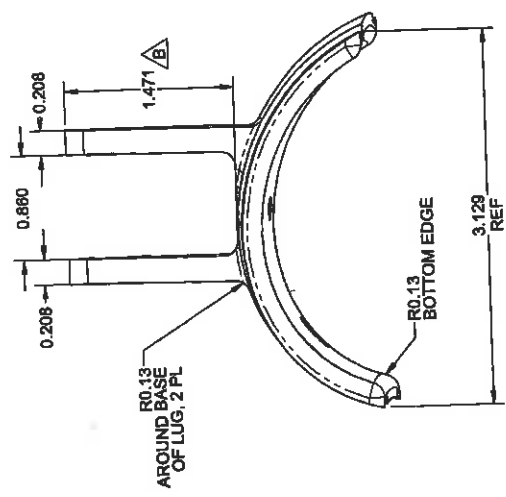
Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	15.05.14	New Issue	KJ	
B	15.10.14	Reference dimensions removed	KJ	

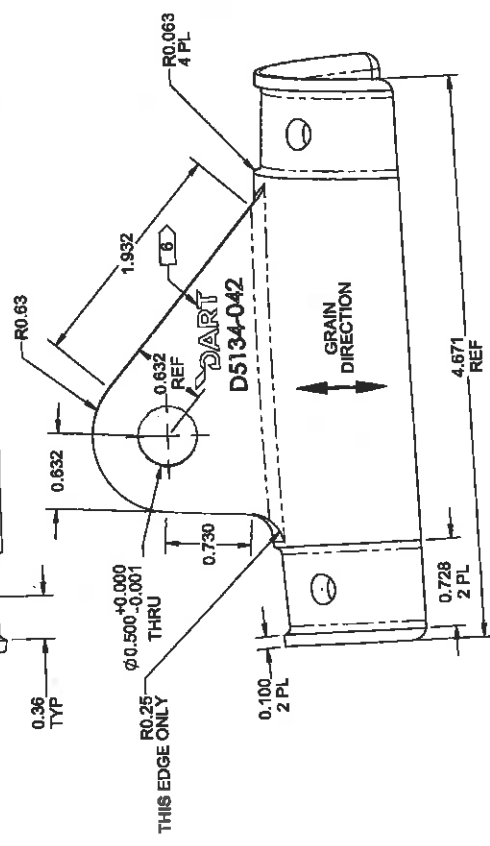
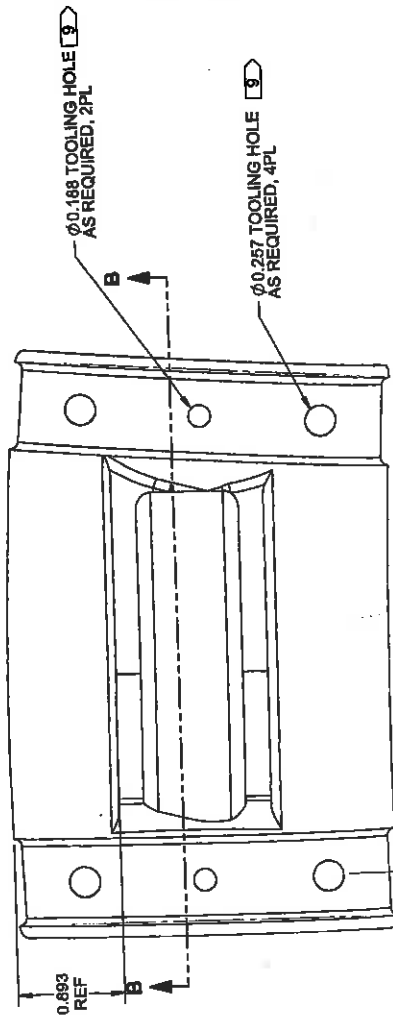
1 2 3 4 5 6 7 8



SECTION B-B



RELEASED
2015 MAY 12
AR EN 5-570



D5134-2 DAMPER SUPPORT, RH

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078) REF DART SPEC M7075T738
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005.4.1
 - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND PIN "D5134-042" IN AREA SHOWN USING 0.125 HIGH X 0.010 X 0.020 DEEP LETTERING PER DART QSI 044 6.3. IDENTIFY WITH DART BIN PER DART QSI 044 6.1
 - 7) WEIGHT: 0.38 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-2-REV.B.SUPPRT"
 - 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES

DESIGN	AP	DART AEROSPACE LTD
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	DRAWING NO.
MFG. APPR.	JLM	D5134
DE APPR.	HS	TITLE
DATE	DSC	DAMPER SUPPORT ASSY
15.04.24		SCALE
		NTS

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